



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4776-3

Job Sheet 177252



Part No: D4776-3

Job Qty: *20 ea*

Part Name: Skidtube Clevis



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/9/18

Job Tracking No:

Created By: Linda Lacelle

Due Date: 5/16/18

Type: Stock

Description:

Note: DWG REV D SHEET 2 IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:C AS PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	14 Ea	5/16/18	5/16/18	0.00	0.00	Start Up Machining-3		<i>mmmk 18/05/18</i>
100	Bandsaw	14 pcs	5/16/18	5/16/18	0.00	0.25	Bandsaw1		"
110	CNC Vertical Machining	14 pcs	5/16/18	5/16/18	0.26	12.17	HAAS1-5		"
120	QC	14 pcs	5/16/18	5/16/18	0.00	0.00	QC2 Machining-3		"
130	QC	14 pcs	5/16/18	5/16/18	0.00	0.00	QC8 Machining-3		<i>9nd 18/05/18</i>
140	HandFinish	14 pcs	5/16/18	5/16/18	0.00	0.37	HandFinish1		<i>SA 19-05-18</i>
150	QC	14 pcs	5/16/18	5/16/18	0.00	0.00	QC7-4		<i>BE 18-05-18</i>
160	Powdercoat	14 pcs	5/16/18	5/16/18	0.00	0.17	Powdercoat1	<i>BEB</i>	<i>BE 18-05-18</i>
170	QC	14 pcs	5/16/18	5/16/18	0.00	0.00	QC3	<i>ST 115</i>	<i>MAY 15 2018</i>
180	Packaging	14 pcs	5/16/18	5/16/18	0.00	0.00	Packaging3-2		<i>MAY 15 2018</i>
190	QC21-SA	14 Ea	5/16/18	5/16/18	0.00	0.00	QC21		<i>MAY 15 2018</i>

Part Op 100 - Cut Blank at 4.400"

Descriptions: 110 - 1-Machine per folio FB168

160 - START TIME: *11:35* *OL TO 320° FINISH: 12:05*

N B 8760

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X02.500	6061-T6 Bar 1.50 X 2.50	5.1380 ft (.367 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.500X02.500	5	49	0



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Container No: S070375



Part: D4776-3

Job No: 177252

Serial No/Batch: S070375

Revision:

Inspector:

Plex 5/9/18 8:15 AM dart.lacelle.linda

Date: 05/10/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Skidtube Clevis	4.250Inches $\pm$ 0.030	4.280 4.220		
2	Skidtube Clevis	2.250Inches $\pm$ 0.030	2.280 2.220		
3	Skidtube Clevis	1.688Inches $\pm$ 0.010	1.698 1.678		
4	Skidtube Clevis	0.880Inches $\pm$ 0.030	0.910 0.850		
5	Skidtube Clevis	0.510Inches + 0.010 - 0.000	0.520 0.510		
6	Skidtube Clevis	1.063Inches $\pm$ 0.010	1.073 1.053		
7	Skidtube Clevis	1.380Inches $\pm$ 0.030	1.410 1.350		
8	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160		
9	Skidtube Clevis	1.000Inches $\pm$ 0.030	1.030 0.970		
10	Skidtube Clevis	0.484Inches + 0.006 - 0.001	0.490 0.483	Diameter	
11	Skidtube Clevis	0.500Inches $\pm$ 0.030	0.530 0.470		
12	Skidtube Clevis	0.550Inches $\pm$ 0.030	0.580 0.520		
13	Skidtube Clevis	3.150Inches $\pm$ 0.010	3.160 3.140		
14	Skidtube Clevis	1.130Inches $\pm$ 0.030	1.160 1.100		
15	Skidtube Clevis	0.688Inches $\pm$ 0.010	0.698 0.678		
16	Skidtube Clevis	0.397Inches + 0.006 - 0.001	0.403 0.396	Diameter	
17	Skidtube Clevis	1.813Inches $\pm$ 0.010	1.823 1.803		
18	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160	Radius	
19	Skidtube Clevis	0.130Inches $\pm$ 0.030	0.160 0.100	Radius	
20	Skidtube Clevis	0.440Inches $\pm$ 0.030	0.470 0.410	Radius	
21	Skidtube Clevis	0.125Inches $\pm$ 0.010	0.135 0.115		
22	Skidtube Clevis	0.380Inches $\pm$ 0.030	0.410 0.350		
23	Skidtube Clevis	0.750Inches $\pm$ 0.030	0.780 0.720		
24	Skidtube Clevis	0.250Inches $\pm$ 0.030	0.280 0.220	Radius	

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